

CCL-FS

ENGINEERING CHANGE PROPOSAL (ECP), PAGE 1				1. DATE (YYMMDD) 010503		Form Approved OMB No. 0704-0188	
Public reporting burden for this collection of information is estimated to average 2 hour per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington VA 22202-4302 and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188) Washington, DC 20503. PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT/PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.						2. PROCURING ACTIVITY NO. LIS3030	
						3. DODAAC	
4. ORIGINATOR a. TYPED NAME (First, Middle Initial, Last) GENERALDYNAMICS ARMAMENT SYSTEMS		b. ADDRESS (Street, City, State, Zip Code) 291 NORTH STREET SACO, ME 04072		5. CLASS OF ECP 1			
				6. JUST. CODE P		7. PRIORITY R	
8. ECP DESIGNATION a. MODEL/TYPE .50 CAL MG				b. CAGE CODE 26978		c. SYSTEM DESIGNATION BMG, CAL .50:M2	
				9. BASELINE AFFECTED <input type="checkbox"/> FUNCTIONAL <input checked="" type="checkbox"/> PRODUCT <input type="checkbox"/> ALLOCATED			
d. ECP NO. 0075-E-0008				e. TYPE F		f. REV	
				10. OTHER SYS./CONFIG. ITEMS AFFECTED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO			
11. SPECIFICATIONS AFFECTED				12. DRAWINGS AFFECTED			
	CAGE Code	Specification/Document No	Rev	CAGE Code	Number	Rev	NOR
a. SYSTEM				19205	5351211		
b. DEVELOPMENT							
c. PRODUCT							
13. TITLE OF CHANGE Coating thickness on the Headspace Gage							
14. CONTRACT NO. AND LINE ITEM DAAE20-00-D-0075/0001 LINE ITEM 0001				15. PROCURING CONTRACTING OFFICER			
				a. NAME (First, Middle Initial, Last) Kristan A. Mendoza			
				b. CODE AMSTA-LC-CSCA		c. TELEPHONE NO. 309-782-0243	
16. CONFIGURATION ITEM NOMENCLATURE BMG, CAL .50:M2 HB						17. IN PRODUCTION <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	
18. ALL LOWER LEVEL ITEMS AFFECTED							
a. NOMENCLATURE Gage, Headspace CAL .50				b. PART NUMBER 5351211		c. NSN	
19. DESCRIPTION OF CHANGE This ECP proposes to change the chromium plating thickness on the Headspace Gage to .0001 minimum							
20. NEED FOR CHANGE The current specification is for .00025 inches of chrome thickness on the surface of the part. The ideal case is to plate the minimum amount of chrome on a correctly sized part and end up with an overall part thickness that meets							
CONTINUED							
21. PRODUCTION EFFECTIVITY BY SERIAL NUMBER N/A				22. EFFECT ON PRODUCTION DELIVERY SCHEDULE N/A			
23. RETROFIT							
a. RECOMMENDED ITEM EFFECTIVITY None				b. SHIP/VEHICLE CLASS AFFECTED N/A			
c. ESTIMATED KIT DELIVERY SCHEDULE N/A				d. LOCATION OF SHIP/VEHICLE NUMBERS AFFECTED N/A			
24. ESTIMATED COST/SAVINGS UNDER CONTRACT N/A				25. ESTIMATED NET TOTAL COSTS/SAVINGS N/A			
26. SUBMITTING ACTIVITY a. AUTHORIZED SIGNATURE <i>[Signature]</i>				b. TITLE Configuration Manager			
27. APPROVAL/DISAPPROVAL							
a. CLASS I <input type="checkbox"/> APPROVED <input type="checkbox"/> DISAPPROVED		b. CLASS II <input type="checkbox"/> APPROVED <input type="checkbox"/> DISAPPROVED		c. CLASS III <input type="checkbox"/> CONCUR IN CLASSIFICATION OF CHANGE <input type="checkbox"/> DO NOT CONCUR IN CLASSIFICATION OF CHANGE			
d. GOVERNMENT ACTIVITY				e. SIGNATURE		f. DATE SIGNED (YYMMDD)	
g. APPROVAL <input checked="" type="checkbox"/> APPROVED Ronald E. Elbe <input type="checkbox"/> DISAPPROVED Chief, CCAG Prod & Eval Spt Team				i. SIGNATURE <i>[Signature]</i>		j. DATE SIGNED (YYMMDD) 20010629	

BLOCK20, NEED FOR CHANGE (CONTD)

the print requirements. The part thickness dimension has a tolerance of .0005 inches. Because of the nonuniform deposition of chrome, the variation in chrome thickness is up to .0003 inches (the chrome being generally thicker around the edges of the part). The variation in the part's overall thickness dimension would then be .0006 inches. Additionally, the grinding tolerance prior to plating the gage is .0002 inches. The total manufacturing tolerance for thickness is therefore the sum of the two tolerances, or .0008 inches which exceeds the part thickness tolerance.